

Work Order ID 77367

77367

Page 1

Tuesday, December 06, 2011 11:00:54 AM

Item ID: D4532-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Pilot Panel
 Start Date: 12/6/2011 Start Qty: 1.00 ***1*** Cust Item ID: *Eagle*
 Required Date: 12/8/2011 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: *mrf* Date: *11-12-06* Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4532	A								

100 0.00
100 FLOW WATER JET *B11-12-06*
 Waterjet Memo 0.00
 FLOW CNC Waterjet 1-Cut as per Dwg
 Dwg Rev: *A*
 Prog Rev: *A* ①
 2-Deburr if necessary
 110 0.00
110 QC2- Inspect parts off machine FAI/FAIB
 QC Memo 0.00
 Quality Control *B11-12-06*

Tuesday, December 06, 2011 11:00:54 AM

77367

Page 3

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 12/6/2011 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 12/8/2011 **Req'd Qty:** 1.00 *** 1 ***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

**Insp.
Stamp**

Identify as per dwg & Stock Location:

0.00

150

Packaging

Memo

0.00

Packaging

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

u/12/87

mf
11-12-05

Picklist Print

Tuesday, December 06, 2011 11:00:54 AM

Page 1

Work Order ID: 77367

Parent Item: D4532-3

Parent Item Name: Pilot Panel

Start Date: 12/6/2011

Required Date: 12/8/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP 11.11.30 new issue EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.125 6061-T6 .125 Sheet		Purchased	No			100	sf	79.8400	2.28	2.4			

Location

Loc Qty

Loc Code

MAT021

79.84

113608

65.35

118217

14.49

113608

11-12-6

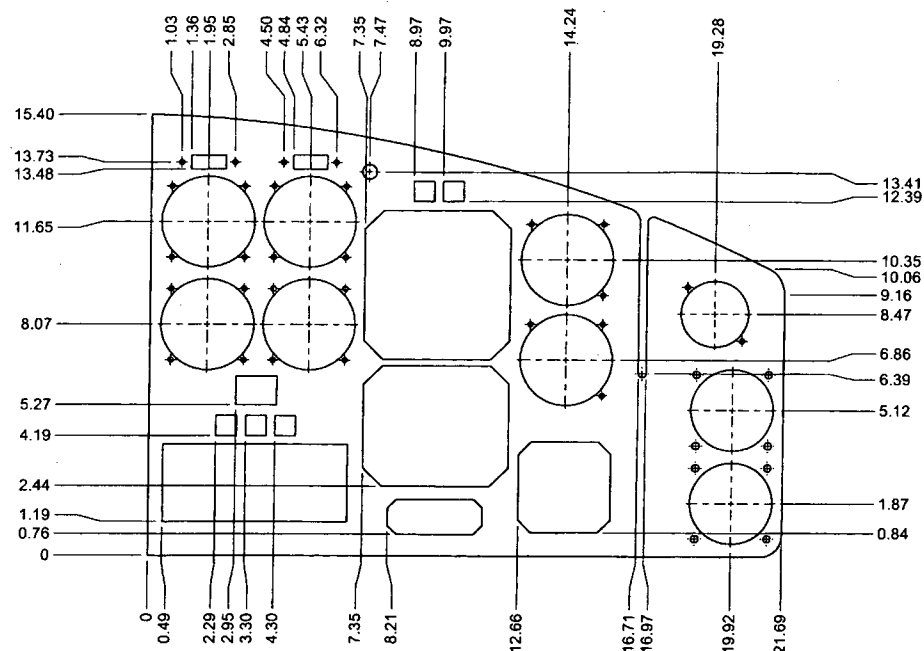
①



NOTES:
1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.125 THICK
PER QQ-A-250/4 OR AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209
REF DART SPEC M2024T3S.125
OR
6061-T6/T62 ALUMINUM SHEET, 0.125 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.125
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES TO .005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
7) WEIGHT: 1.70 lbs

RELEASED
2011-12-11

DESIGN	<i>JS</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. 1 SHEET 3 OF 4
DRAWN	<i>JS</i>		
CHECKED	<i>JS</i>	DRAWING NO. D4532	SCALE INCHES TO FEET
MFG. APPR.	<i>JS</i>	TITLE INSTRUMENT PANEL	
APPROVED	N/A	COPYRIGHT © 2011 BY DART AEROSPACE LTD. ALL RIGHTS RESERVED. THIS DRAWING IS TO BE KEPT CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM, WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	DATE 11:11:29
DE APPR.	N/A		



D4532-3 PILOT PANEL
AUXILIARY VIEW

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4532	SHEET 4 OF 4
APPROVED	N/A	TITLE	SCALE
DE APPR.	N/A	INSTRUMENT PANEL	
DATE	11-11-29	<small>COPYRIGHT © 2011 BY DART AEROSPACE LTD. THIS DOCUMENT IS UNCLASSIFIED AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

DART AEROSPACE LTD	Work Order: 77367
Description: P.10T PANEL	Part Number: D453D-3
Inspection Dwg: D453D-3 Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .170	+ .005 - .001	.173	2		V BOL	
Ø .250	+ .005 - .001	.252	2		V	
Ø .500	+ .006 - .001	.502	2		V	
Ø 2.300	+ .012 - .001	2.308	2		V	
Ø 2.830	+ .012 - .001	2.830	2		V	
Ø 3.170	+ .012 - .001	3.169	2		V	
.70	± .030	.702	2		V	
.50	± .030	.499	2		V	
.118	± .030	1.181	2		V	
1.40	± .030	1.398	2		V	
1.00	± .030	1.000	2		V	
2.70	± .030	2.696	2		V	
6.32	± .030	6.315	2		V	
1.22	± .030	1.219	2		V	
3.22	± .030	3.222	2		V	
3.17	± .030	3.166	2		V	
4.95	± .030	4.947	2		V	
4.20	± .030	4.196	2		V	
5.20	± .030	5.193	2		V	
.84	± .030	.842	2		V	
1.87	± .030	1.87	2		V	
5.12	± .030	5.12	2		V	
6.34	± .030	6.34	2		V	

Measured by: RB	Audited by: J	Prototype Approval:
Date: 11-12-6	Date: 11/12/67	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

DART AEROSPACE LTD	Work Order: 77367
Description: P16T PANEL	Part Number: D4535-3
Inspection Dwg: D4535-3 Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
6.86	±.030	6.86	2		+ B01	
8.47	±.030	8.47	2		T	
10.35	±.030	10.35	2		T	
12.39	±.030	12.39	2		T	
13.41	±.030	13.41	2		T	
176	±.030	176	4		V B02	
1.19	±.030	1.194	2		V	
2.44	±.030	2.444	2		V	
4.19	±.030	4.191	2		V	
5.27	±.030	5.272	2		V	
8.07	±.030	8.07	2		T	
11.65	±.030	11.65	2		T	
13.48	±.030	13.48	2		T	
13.73	±.030	13.73	2		T	
15.40	±.030	15.40	2		T	
149	±.030	149	2		V	
2.29	±.030	2.291	2		V	
2.95	±.030	2.954	2		V	
3.36	±.030	3.366	2		V	
4.30	±.030	4.302	2		V	
7.35	±.030	7.352	2		V	
8.21	±.030	8.212	2		T	
12.66	±.030	12.66	1		T	

Measured by: RB	Audited by: S	Prototype Approval:
Date: 11-12-6	Date: 11/12/69	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

